



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D3674-045

Job Sheet 205330



Part No: D3674-045

Job Qty: 4 pcs

Part Name: Roller Bracket Assembly

8 pcs. B.A.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/7/20

Job Tracking No:

Due Date: 2/7/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP rev: A RQ Verified by: DD 16.06.24

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	2/7/20	2/7/20	0.00	0.18	Bandsaw - 1		B.A. 20-01-31
110	HAAS 5 Axis - B4B	4 pcs	2/7/20	2/7/20	1.14	4.76	HAAS - 1 - 5 - B4B		
							HAAS - 2 - 5 - B4B		B.A. 20-01-31
120	QC 2	4 pcs	2/7/20	2/7/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		B.A. 20-01-31
							QC 2 - 66		



Container No: S253661



Part: D3674-045

Job No: 205330

Serial No/Batch: S253661

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/06/20

Plex 1/7/20 3:00 PM

art.lajeunesse.marie

130 QC 8	4 pcs	2/7/20	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	J.C.L. 20-02-06
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
140 Small Fab - 2 - B4B	4 pcs	2/7/20	0.00 0.08	QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
150 QC 5	4 pcs	2/7/20	0.00 0.00	Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	

FEB 07 2020

DAS
81
9-89

FEB 10 2020

			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
160 Packaging 3-1 - Stock - B4B 4 pcs	2/7/20	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	DAS
			Packaging 3 - 23 - B4B	84
			Packaging 3 - 24 - B4B	9-89
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
170 QC 21 - SA	4 pcs	2/7/20	QC 21 - SA - 21	
			QC 21 - SA - 70	DAS
			QC 21 - SA - 53	70

Part Op 100 - (Bandsaw) Cut blanks: 4.50" long
 Descriptions: 110 - (HAAS CNC vertical machine #5) 1- Machine D3674-5 as per Folio FB482 and Dwg. D3674.
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Small Fab) Assemble D3674-045 as per Dwg D3674
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B0.500X2.000	17-4 SS Bar .500 x 2.00	1.5000 ft (.375 ea)	100-Bandsaw - 1	3.00 used
D3137-5	Washer	4 pcs (1 ea)	140-Small Fab - 2 - B4B	0.25 ft scraped
D3674-7	Guide	4 pcs (1 ea)	140-Small Fab - 2 - B4B	
MS24694-S100	Flat Head Screw	4 Ea (1 ea)	140-Small Fab - 2 - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B0.500X2.000	2	11	0
140-Small Fab - 2 - B4B	D3137-5	4	49	0
	D3674-7	4	0	0
	MS24694-S100	4	26	0
Part Specifications				
Specifications could not be found.				

Plex 1/7/20 3:00 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 205330
Description: Roller Bracket Assembly		Part Number: D3674-045
Inspection Dwg: D3674	Rev: B	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.21	+/-0.030	4.211	✓		Vern	GA-13
2.20	+/-0.030	2.202	✓		H-6	31006
2.10	+/-0.030	2.102	✓		"	"
0.220	+/-0.010	0.220	✓		Vern	GA-13
0.72	+/-0.030	0.720	✓		"	"
15°	+/-0.5°	15°	✓		Angle M.	CNC-17
R0.25	+/-0.030	R0.250	✓		R-6	ref.
18°	+/-0.5°	18°	✓		Angle M.	CNC-17
R0.42	+/-0.030	R0.420	✓		R-6	ref.
1.90	+/-0.030	1.901	✓		Vern	GA-13
0.350	+/-0.010	0.351	✓		"	"
0.162	+/-0.010	0.163	✓		"	"
R0.06	+/-0.030	R0.063	✓		R-6	ref.
Ø0.563	+/-0.010	Ø0.564	✓		Vern	GA-13
1/4-28 UNF	N/A	1/4-28 UNF	✓		60/nogo	ref.
3.794	+/-0.010	3.794	✓		Vern	GA-13
1.76	+/-0.030	1.760	✓		"	"
0.88	+/-0.030	0.880	✓		"	"
0.25	+/-0.030	0.250	✓		"	"
0.032	+/-0.010	0.030	✓		D-6	GA-08
60°	+/-0.5°	60°	✓		A-6	ref.
0.050	+/-0.010	0.050	✓		Vern	GA-13
0.200	+/-0.010	0.199	✓		"	"
0.235	+/-0.010	0.238	✓		"	"
100°	+/-0.5°	100°	✓		Vern	GA-13
0.390	+/-0.010	0.390	✓		"	"
0.080 0.000	+/-0.010	0.080	✓		"	"

Measured by: Ba	Checked by: J.C.V.	QC Inspector:
Date: 20-01-31	Date: 20-02-06	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised By	Approved
A	16.08.30	New Issue	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					